

5/42

DART AEROSPACE LTD	Work Order:	24614
Description: Plate	Part Number:	D3163-3
Dwg: D3163 Rev. B	Qty:	6
		Page 1 of 1


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JS	05.10.18	6
2	PG	Issue P/O: <u>2008644</u> Email or Ship DXF file to vendor Laser Cut D3163-3 flat pattern per Dwg D3163 Possible Supplier: GFI Material release note is required	LL	05-10-18	6
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CL	05/10/18	6
4	QC6	Inspect dimensions as per Dwg D3163	ml	05/10/19	6
5	CA	Deburr	ml	05/10/19	6
6	FP	Chemical Conversion Coat per QSI 005 4.1	FC	051024	6
7	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI 005 4.3			
8	QC3	Inspect Powder Coat QC3 Inspect Conversion Coat	JS	05.10.25	6
9	ST	Identify and Stock in SPACE DOOR ROOM	ml	05-10-25	6
10	AC	Cost / part: <u>31.27</u>	SUR	05.10.27	6
11	DC	Close W/O <u>31.27</u> Inspect Level 21	ID	05/	

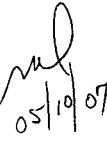
PTO


JS
05.10.21

Rev	Date	Change	Revised By	Approved
A	05.09.27	New issue	KJ/RF	JS

RELEASED
05.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
							 05-10-27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-07	4	Made Test for sikaflex in oven Before working on good pieces		Used 9 1/2" x 7 1/4" of 2024-T3 .063 m 18133 20" x 7 1/4" of 2024-T3 .032 m 15120	 05/10/07			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

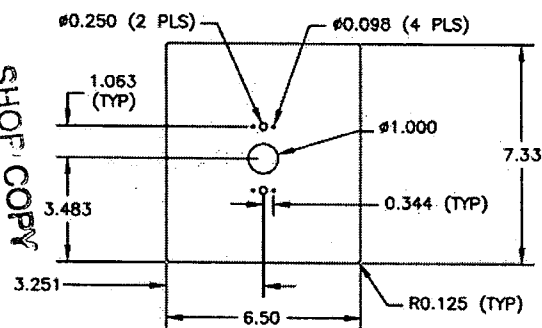
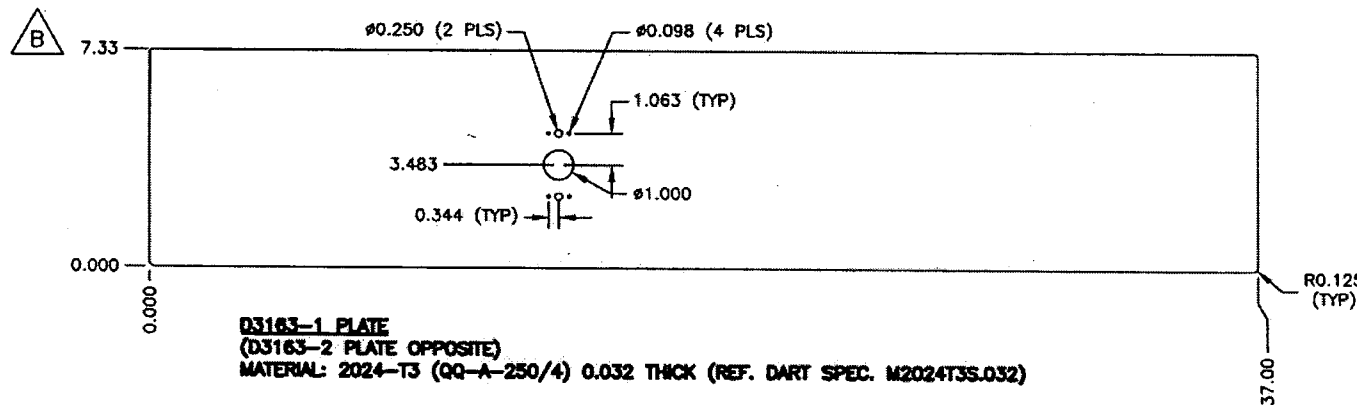
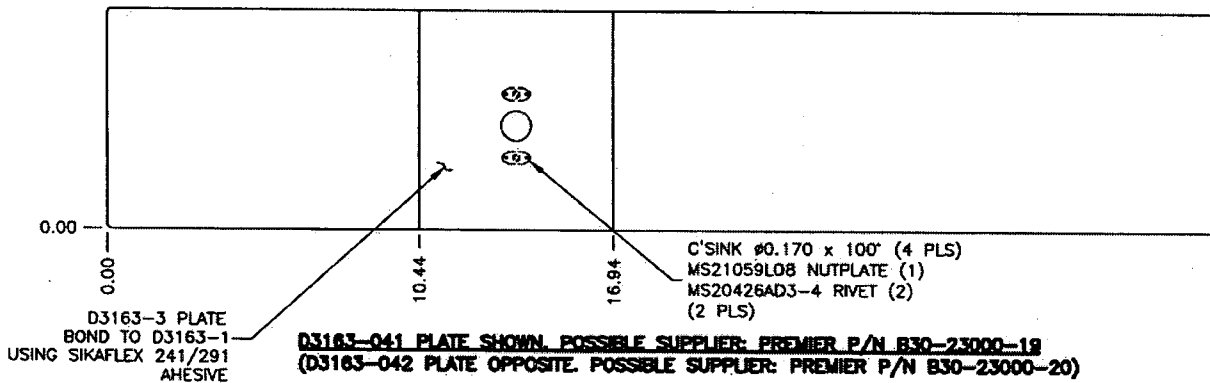


DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV. B
✓	✓	D3163	SHEET 1 OF 1
CHECKED	APPROVED	DATE	
✓	✓	04.10.06	
DATE		TITLE	SCALE
04.10.06		PLATE	1:6

A	02.04.26	NEW ISSUE
B	04.10.06	7.33 WAS 7.20; REMOVE PERIMETER HOLES

RELEASED
04.11.23



- GENERAL NOTES:**
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
 - 2) BREAK SHARP EDGES 0.005 TO 0.010
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
CONTROL COPY

NO. 24614

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 19, 2005
07:44 am

Work Order No : 0024614
Project Name : D3163-3
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3163-3
Description : Plate
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-19-05
Est Finish Date : 10-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0133195 SHIPPING MEMO 0320142

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>1</u>	<u>6 PCS</u>	<u>2008644</u>	<u>D3163-3</u>	<u>B</u>	<u>PLATE</u>	<u>B</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 2024-T3 (QQ-A-250/4)</u>		<u>KAISER ALUMINUM</u>		<u>310277A9 ATT'D</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 11 OCTOBER 2005

G.F.I. Q.C. REP. Dalton Hard



142-05

**LES MÉTAUX
SPÉCIALISÉS
SAMUEL**

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ – LETTER OF COMPLIANCE

Date: 17 Mars 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058571

de commande SSMQ: 839445

Customer's order #:


SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	4	.063" x 48" x 144"	2024 T3	AMS-QQ-A-250/4	310277A9

Bien à vous,
Yours truly,



Commis à l'administration.
Administration Clerk.



SHIP TO:

LES METAUX SPECIALISES SAMUEL
(SHIP TO)
21525 CLARK GRAHAM
BAIE D'URFE, PQ, CA H9X3T5

SOLD TO:

SAMUEL SON & CO LTD
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4010594

CUSTOMER PO NUMBER: N16146		CUSTOMER PART NUMBER:		SHIPPING RUN #/LOAD ID: 100080/1		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1007108	LINE ITEM: 2	SHIP DATE: 25-JUN-2004		ALLOY: 2024	CLAD: BARE	TEMPER: T3	
WEIGHT SHIPPED: 7476 LB	QUANTITY: 168 PCS EST.	B/L NUMBER: 201906		GAUGE: 0.0630 IN	WIDTH: 48.00 IN	LENGTH: 144.000 IN	

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 310277A9 Cast 168

Drop 04

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	66.9 : 68.2 (461 : 470)	44.6 : 45.8 (308 : 316)	16.3 : 17.3

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.23	4.49	0.56	1.39	0.01	0.09	0.01	0.01	0.00	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH MIL-H-6088 (AMS-H-6088). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

